

Millers Falls

METAL CUTTING PRODUCTS

BLU-MOL®
MILLERSFALLS CO.

AND MF SAWS

TUF-FLEX

TUF-FLEX®

BLU-MOL® HIGH-SPEED

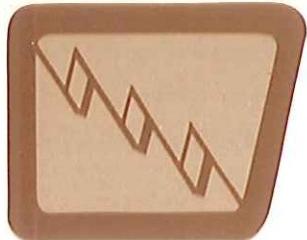
HIGH SPEED @ BLU-FLEX® FLEXIBLE

DEEP CUT
HOLE SAW KIT

BLU-MOL®
MILLERSFALLS CO.

BLU-MOL





Millers Falls

metal cutting products

"BLU-MOL"® HIGH SPEED MOLYBDENUM POWER HACK SAW BLADES

Toughness resists breakage even under severe usage.

Unsurpassed for fast production cutting of tough alloy steels! Heat treated by exclusive Millers Falls process. Made of specially selected high speed molybdenum alloy steel. Extremely hard, long cutting teeth assure low cutting costs.

Packed 10 Per Box.
*30 Per Box.

Cat. No.	Length Inches	Width Inches	Thickness	Teeth Per Inch
*1254M	12	5/8	.032	14
*1258M	12	5/8	.032	18
2410M	12	1	.050	10
2414M	12	1	.050	14
4410M	14	1	.050	10
4414M	14	1	.050	14
4506M	14	1 1/4	.062	6
4510M	14	1 1/4	.062	10
4604M	14	1 1/2	.075	4
4606M	14	1 1/2	.075	6
7410M	17	1	.050	10
7414M	17	1	.050	14
7504M	17	1 1/4	.062	4
7506M	17	1 1/4	.062	6
7510M	17	1 1/4	.062	10
8506M	18	1 1/4	.062	6
8510M	18	1 1/4	.062	10
8604M	18	1 1/2	.075	4
8606M	18	1 1/2	.075	6
8784M	18	1 3/4	.088	4
8786M	18	1 3/4	.088	6
1784M	21	1 3/4	.088	4
1786M	21	1 3/4	.088	6
4784M	24	1 3/4	.088	4
4786M	24	1 3/4	.088	6
●4814M	24	2	.100	4
●3114M	30	2 1/2	.100	4

● 25/64" Pin Hole Standard on these Blades.

"BLU-MOL"® "JET-EDGE"® HIGH SPEED WELDED EDGE POWER HACK SAW BLADES

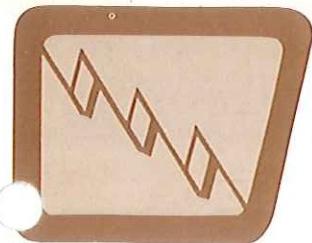
An extra margin of safety under severest cutting conditions.

One of the most sensational performers in the Power Hack Saw field! Unbreakable in use. Savings of 20% to 50% when tested against other blades on actual production runs. Teeth milled in super high speed steel strip and electrically welded to tough shatter-proof steel back.

Packed 10 Per Box.

Cat. No.	Length Inches	Width Inches	Thickness	Teeth Per Inch
2410JE	12	1	.050	10
2414JE	12	1	.050	14
4410JE	14	1	.050	10
4414JE	14	1	.050	14
4506JE	14	1 1/4	.062	6
4510JE	14	1 1/4	.062	10
4604JE	14	1 1/2	.075	4
4606JE	14	1 1/2	.075	6
7410JE	17	1	.050	10
7414JE	17	1	.050	14
7504JE	17	1 1/4	.062	4
7506JE	17	1 1/4	.062	6
7510JE	17	1 1/4	.062	10
8506JE	18	1 1/4	.062	6
8510JE	18	1 1/4	.062	10
8604JE	18	1 1/2	.075	4
8606JE	18	1 1/2	.075	6
8784JE	18	1 3/4	.088	4
8786JE	18	1 3/4	.088	6
1784JE	21	1 3/4	.088	4
1786JE	21	1 3/4	.088	6
4784JE	24	1 3/4	.088	4
4786JE	24	1 3/4	.088	6
●4814JE	24	2	.100	4
●3114JE	30	2 1/2	.100	4
3612JE	36	4 1/2	.125	2 1/2

● 25/64" Pin Hole Standard on these Blades.



Millers Falls

metal cutting products

"BLU-MOL"® DOUBLE LIFE HIGH SPEED POWER HACK SAW BLADES

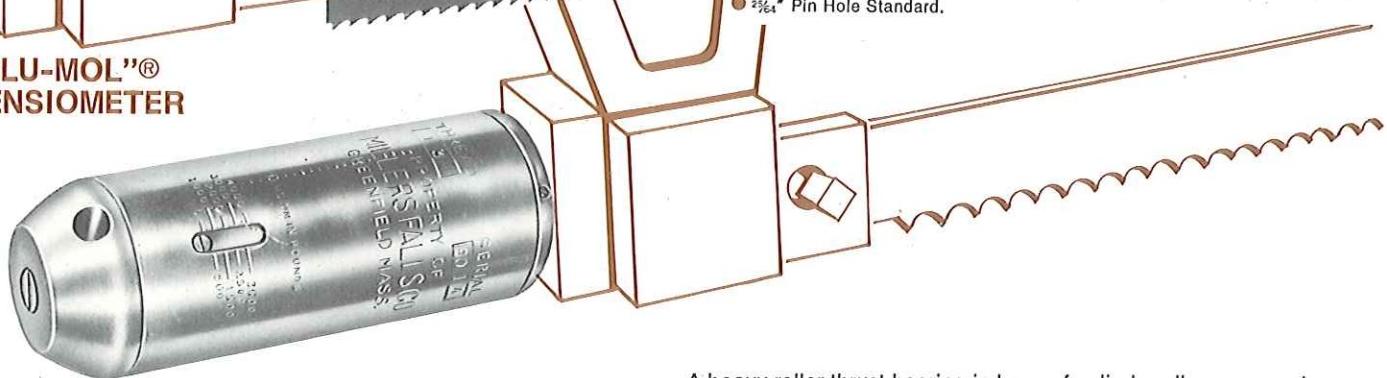
Double Edge for Double Life!

Twice the cuts for only one third more! Only double-life blade made. All the Blu-Mol advantages PLUS double-edged economy. Unbreakable in use. Both cutting edges are identical except that first edge used has greater set enabling second edge to pass through without wear. Welded high speed cutting edge assures twice the cutting without blade fatigue.

Packed 10 Per Box

BLU-MOL
MADE IN U.S.A. MILLERS FALLS CO., WRENTHAM, MASS.

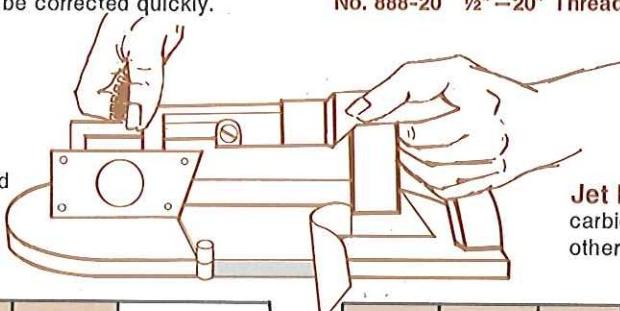
"BLU-MOL"® TENSIO METER



Exclusive, calibrated blade tensioning instrument assures accurate cutting and maximum blade life. Changes in blade tension due to shock, vibration or frictional heat can be eliminated with the Blu-Mol Tensiometer. Encased in the steel cylinder is a heavy, precisely calibrated spring and a graduated index. The spring absorbs sudden strains and stresses that often cause breakage and faulty cutting. Variations in tension register at once and can be corrected quickly.

PORTER BANDS FOR PORTABLE BANDSAW MACHINES

Tuf-Flex. For general purpose, mild steels, tubing, angle, etc. Packed 5 Per Box.



Jet Band. High speed alloy vanadium carbide hardness. Cuts stainless steel and other tough alloys. Packed 3 Per Box.

WELDED EDGE DOUBLE LIFE "BLU-MOL" HIGH SPEED

Cat. No.	Length Inch	Width Inch	Thickness	Teeth Per Inch
WD4506	14"	1 1/4"	.062	6
WD4510	14"	1 1/4"	.062	10
WD4604	14"	1 1/2"	.075	4
WD4606	14"	1 1/2"	.075	6
WD8506	18"	1 1/4"	.062	6
WD8510	18"	1 1/4"	.062	10
WD8604	18"	1 1/2"	.075	4
WD8606	18"	1 1/2"	.075	6
WD1786	21"	1 3/4"	.088	6
WD4784	24"	1 3/4"	.088	4

ONE PIECE DOUBLE LIFE "BLU-MOL" HIGH SPEED

DL4506	14"	1 1/4"	.062	6
DL4604	14"	1 1/2"	.075	4
DL7504	17"	1 1/4"	.032	4
DL8604	18"	1 1/2"	.075	4
DL8606	18"	1 1/2"	.075	6
DL8784	18"	1 3/4"	.088	4
DL1784	21"	1 3/4"	.088	4
DL1814	21"	2"	.100	4
DL4814	24"	2"	.100	4

• 25/64" Pin Hole Standard.



Millers Falls

metal cutting products

TUF-FLEX® CARBON BAND SAWS

TUF-FLEX

Special formula steel for strength and economy even under the toughest cutting applications. Tooth hardness coupled with flexible back assures high resistance to wear and stress breakage. Recommended for general purpose cutting including inside/outside contour work.

See Page 43 for Portable Bands

Catalog No.		Width	Teeth/ Inch	Tooth Type	Tooth Set	Thick- ness		
100 Ft. Coil	250 Ft. Coil							
6B021S100		$\frac{1}{8}$ "	18	Reg.		.025		
6B042S100	6B040S250 6B042S250		4 6	Hook				
6B041S100	6B041S250		4	Skip				
6B043S100	6B043S250		6					
6B044S100	6B044S250		10	Reg.				
6B045S100	6B045S250		12					
6B046S100	6B046S250		14					
6B047S100	6B047S250		18					
6B048S100			24					
6B064S100	6B060S250 6B062S250 6B064S250	$\frac{3}{8}$ "	3 4 6	Hook		.032		
6B063S100	6B063S250		4	Skip				
6B065S100	6B065S250		8	Reg.				
6B066S100	6B066S250		10					
6B068S100	6B068S250		14					
6B069S100	6B069S250		18					
	6B082S250 6B083S250 6B084S250		10 14 18	Wavy		.035		
	6B086S250		24					

BANDS CUT TO LENGTH AND WELDED refer to the above catalog numbers. Use the first 5 digits and add length desired.

Example: $\frac{1}{8} \times .020 \times 10T$ Reg. Raker use 6B321S-6' 6" (or length desired)



MICRO-HONED JET BAND® SAWS

MICRO-HONED JET BAND

Outcuts and outlasts up to seven carbon bands! Vanadium carbide hardness with high fatigue resistance. Exclusive Millers Falls steel formula developed especially for band saws. Handles 80% of the cutting jobs of high speed steel bands at savings of up to 50%.

See Page 43 for Portable Bands

BANDS CUT TO LENGTH AND WELDED refer to the above catalog numbers. Use the first 5 digits and add length desired.

Example: $\frac{1}{8} \times .025 \times 10T$ Reg. Raker use 6B411S-6' 6" (or length desired)



Catalog No.	Width	Teeth/ Inch	Tooth Type	Tooth Set	Thick- ness
250 Ft. Coil					
6B321S250	$\frac{1}{2}$ "	10			.020
6B323S250		14			
6B323S250		18			
6B324S250		24			
6B352S250	$\frac{3}{4}$ "	6			.032
6B353S250		8			
6B354S250		10			
6B356S250		14			
6B355S250	1"	10			.035
6B370S250		3			
6B373S250		4			
6B375S250		6			
6B376S250		8			
6B377S250		10			
6B381S250		6			.042

TUF-TEMPER® BAND SAWS

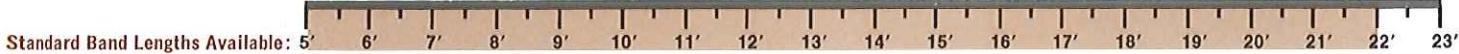
TUF-TEMPER

New improved process makes this a premium quality carbon band. Double heat treat produces hard edge plus flexible spring temper back to minimize breakage. An economical increased tooth life band with greater tensile strength and no stretch to withstand greater feed pressures.

Catalog No.		Width	Teeth/ Inch	Tooth Type	Tooth Set	Thick- ness
100 Ft. Coil	250 Ft. Coil					
6B210S100	6B210S250 6B212S250	1/4"	4 6	Hook	Raker	.025
6B211S100	6B211S250 6B213S250		4 6	Skip		
6B214S100	6B214S250 6B215S100 6B216S100 6B217S100		10 14 18 24	Reg.		
6B218S100			32	Wavy		
6B222S100	6B222S250 6B224S100		4 6	Hook		
6B223S100	6B223S250		4	Skip		
6B225S100	6B226S100 6B227S100		8 10 14	Reg.		
6B228S100			18			

Catalog No.		Width	Teeth/ Inch	Tooth Type	Tooth Set	Thick- ness
100 Ft. Coil	250 Ft. Coil					
6B233S100	6B233S250	1/2"	4	Hook	Raker	.025
6B235S100	6B235S250		6			
6B234S100	6B234S250		4	Skip		
6B236S100	6B236S250		6			
6B237S100	6B237S250		10			
6B239S100	6B239S250		14			
6B241S100	6B241S250		18			
6B238S100	6B238S250		10	Reg.		
6B240S100	6B240S250		14			
6B242S100	6B242S250		24			
6B251S100	6B251S250	5/8"	10		Wavy	.025
6B253S100	6B253S250		14			
	6B261S250		3	Hook		
	6B263S250		6			
6B262S100			3	Skip		
6B264S100	6B264S250		6			
6B265S100	6B265S250		8			
6B267S100	6B267S250		10	Reg.		
6B269S100	6B269S250		12			
6B271S100	6B271S250		14			
	6B266S250	3/4"	8		Wavy	.032
6B268S100	6B268S250		10			
6B270S100	6B270S250		12			
6B272S100	6B272S250		14			
	6B273S250		18			
6B277S100	6B277S250		3	Hook		
6B280S100	6B280S250		6			
6B281S100	6B281S250		8	Reg.		
6B282S100	6B282S250		10			
6B284S100	6B284S250		14			
6B283S100	6B283S250		10			

BANDS CUT TO LENGTH AND WELDED refer to the above catalog numbers. Use the first 5 digits and add length desired.
Example: 1/2 x .025 x 18T Reg. Wavy use 6B103S—6' 6" (or length desired)



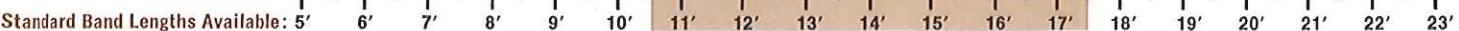
BLU-MOL® BAND SAWS

BLU-MOL

Cuts 10 times faster than carbon bands! Takes over where other bands leave off. Ideal for cutting high alloy steels. Specially designed for production cut-off work; handles heavier feeds at higher speeds than competitive bands. 20% longer life than other high speed steel bands. Extremely tough and flexible with super-hard teeth, hardness held at cutting temperatures up to 1100°F. "Micro-Honed" process yields sharper teeth and maximum fatigue resistance.

Catalog No.	Width	Teeth/ Inch	Tooth Type	Tooth Set	Thick- ness
250 Ft. Coil					
6B411S250	1/2"	10	Raker	.025	.025
6B422S250	3/4"	6			
6B423S250		8			
6B424S250		10			
6B440S250	1"	3	Hook	.035	.035
6B442S250		4			
6B445S250		6			
6B460S250		3			
6B444S250		4			
6B446S250	Reg.	6	.035	.035	.042
6B447S250		8			
6B448S250		10			
6B481S250		6			

BANDS CUT TO LENGTH AND WELDED refer to the above catalog numbers. Use the first 5 digits and add length desired.
Example: 1/2 x .025 x 4T Hook Raker use 6B233S—6' 6" (or length desired)



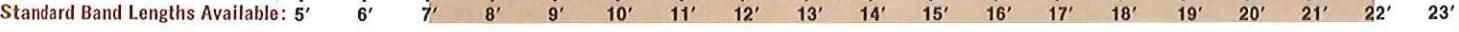
"BLU-MOL"® WELDED EDGE BAND SAWS

BLU-MOL

Fabricated with two selected metals welded together to produce a blade with up to four times better performance than other one-piece high speed steel blades. The welded band results in a uniformly hard, high abrasion resistant tooth with a flexible, highly resilient and fatigue resistant back. Blade can be welded on standard blade welding equipment.

Catalog No.	Width	Teeth/ Inch	Tooth Type	Tooth Set	Thick- ness		
100 Ft. Coil	150 Ft. Coil						
6B621S100	1/2"	10	Raker	.035	.035		
6B622S100		14					
		6	Reg.				
		10					
		10					
6B644S150		3	Hook	.042	.042		
6B649S150		4					
6B650S150		6					
6B651S150	1"	10	Raker	.042	.042		
6B652S150		6					
6B654S150		10					

BANDS CUT TO LENGTH AND WELDED refer to the above catalog numbers. Use the first 5 digits and add length desired.
Example: 1/2 x .035 x 10T Reg. Raker use 6B621S—6' 6" (or length desired)





Millers Falls

metal cutting products

HOLE SAW/MANDRELS/ACCESSORIES



BLU-MOL® HOLE SAWS

Designed for wide use and application in the metal cutting industries, plumbing, electrical, and automotive trades. Saw follows through completely, knock-out slots permit easy core removal. Molybdenum high speed steel cutting edge welded to shatter-proof steel back for safer cutting in all machinable materials.

- 1 1/8" depth of cut
- 6 teeth per inch
- Follow through design
- Over 50 sizes—1/16" through 6" diameter

See Selector Chart on page 47



DEEP CUT HOLE SAWS

Essential tools for the journeyman. 15 sizes available for cutting 1" to 4 1/2" diam. holes in metal pipe, wood, sheet-rock and plaster. High speed steel cuts easily through obstructions such as nails and screws.

- High speed steel cutting edge
- Welded edge shatter proof construction
- Cuts holes up to 2 1/2" deep
- Follow through design
- 15 sizes—1" to 4 1/2" diameter

See Selector Chart on page 47



MODEL 3801 DEEP CUT HOLE SAW KIT

Ideal for mechanics, maintenance crews, electricians, plumbers, construction workers and appliance installers.

Kit Contains: one each 3816, 3818, 3820, 3822, 3828, 3832, 3836, 3840, 3852 and 3864 Deep Cut Hole Saws; one each 8540 and 8550 Mandrels; one 5500 Extension.

Packed in metal case with formed insert.

See Selector Chart on page 47

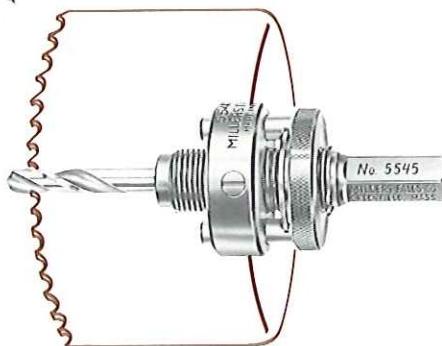


BLU-JET® HOLE SAWS

Designed to cut thin metal with cleaner, burr-free holes. Unique tooth set design maintains consistently rounder holes in sheet metal stock. 4 teeth per inch and thin blade permit higher operating speeds and less feed pressures.

- For all types of sheet metal and light gauge applications
- Shatter-proof welded edge construction
- 1/2" cutting depth

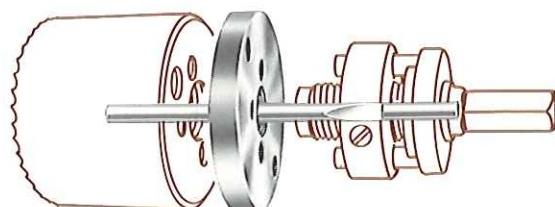
See Selector Chart on page 47



MANDRELS

For Blu-Mol, Blu-Jet and Deep Cut Hole Saws. Mandrels complete with high speed 1/4" pilot drill. Deep Cut Hole Saws use mandrel with 3/16" high speed pilot drill. Shank will fit any two or three jawed chuck. All mandrels are fully heat treated and provide positive drive to hole saw. No. 5545 Quick-Change Mandrel (for hole saws 1 1/4" through 6") allows easy changing of hole saws. Drive pins can be readily advanced or retracted without removing mandrel from chuck providing fast time-saving change-overs.

See Selector Chart on page 47



HIGH-TORQUE DRIVING PLATES

Available in two sizes for driving hole saws. Eliminates shearing mandrel drive pins. Distributes torque over greater driving area permitting greater feeds and speeds.

Cat. No.	Fits Blu-Mol Hole Saw Nos.
5506	548-570
5507	572-596

HOLE SAW / MANDREL SELECTOR CHART

MANDREL ACCESSORIES



No. 5511 Mandrel

Adaptor. Threaded adaptor and washer allows Mandrel Nos. 5514 and 5518 to be used with hole saw No. 520 thru 524 and 8626 thru 8630 under light duty cutting conditions.



No. 8535 1/4" Pilot Drill.

Original equipment replacement 1/4" pilot drill for Mandrel Nos. 5514, 5518, 5520, 5545 and 5572.



No. 8525 3/8" Pilot Drill.

Original equipment replacement 3/8" pilot drill for Mandrel Nos. 8540 and 8550.



No. 5500 12" Extension.

A 12" extension for use in hard to reach places. For 7/16" hex shank Mandrel Nos. 5518, 5520, 5545, 8540, and 8550.

Mandrel Cat. No.	Deep Cut Hole Saws	Hole Dia. Inch	BLU MOL HOLE SAWS	BLU JET HOLE SAWS	Mandrel Cat. No.	Recommended Clearances				
						Pipe			Tubing	
						Tap Size	Entr. Size	Coupling	Size	Coupling
Use Mandrel 8540 7/16" Hex Shank	3816	5/16	509	8616	Use Mandrel 5514 1/4" Rd. or 5518 7/16 Hex Shank	5/8	1/4			
		5/8	510			5/8	5/8			
		11/16	511			1/2				
		3/4	512	8618						
		13/16	513							
		7/8	514	8620						
		15/16	515							
		1	516	8622						
		1 1/16	517							
		1 1/8	518	8624		1	3/4	3/8	3/4	1/2
Use Mandrel 8550 7/16" Hex Shank	3818	1 1/8	519			1	1	1/2	1	3/4
		1 1/4	520	8626						
		1 1/16	521							
		1 3/8	522	8628						
		1 7/16	523							
		1 1/2	524	8630						
		1 9/16	525							
		1 5/8	526	8632						
		1 11/16	527							
		1 3/4	528	8634						
Use Mandrel 8550 7/16" Hex Shank	3822	1 13/16	529							
		1 7/8	530	8636						
		2	532	8637						
		2 1/16	533							
		2 1/8	534	8639						
		2 1/4	536	8640		2		1 1/4	2	
		2 5/16	537							
		2 3/8	538	8642						
		2 1/2	540	8643						
		2 7/16	541							
Use Mandrel 8550 7/16" Hex Shank	3824	2 5/8	542							
		2 3/4	544	8646						
		2 7/8	546							
		3	548	8648						
		3 1/8	550							
		3 1/4	552							
		3 3/8	554							
		3 1/2	556							
		3 5/8	558							
		3 3/4	560							
Use Mandrel 8550 7/16" Hex Shank	3828	3 7/8	562							
		4	564							
		4 1/8	566							
		4 1/4	568							
		4 3/8	570							
		4 1/2	572							
		4 3/4	576							
		5	580							
		5 1/2	588							
		5 3/4	592							
Use Mandrel 8550 7/16" Hex Shank	3832	6	596							
Use Mandrel 8550 7/16" Hex Shank	3836									
Use Mandrel 8550 7/16" Hex Shank	3840									
Use Mandrel 8550 7/16" Hex Shank	3844									
Use Mandrel 8550 7/16" Hex Shank	3848									
Use Mandrel 8550 7/16" Hex Shank	3852									
Use Mandrel 8550 7/16" Hex Shank	3856									
Use Mandrel 8550 7/16" Hex Shank	3864									
Use Mandrel 8550 7/16" Hex Shank	3872									

47



2736C

* Denotes carded or packed in vinyl pouch.

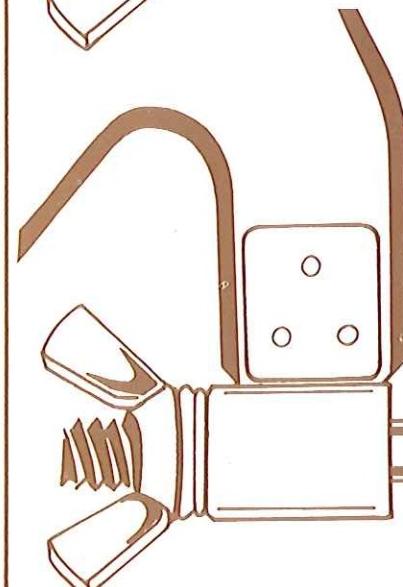
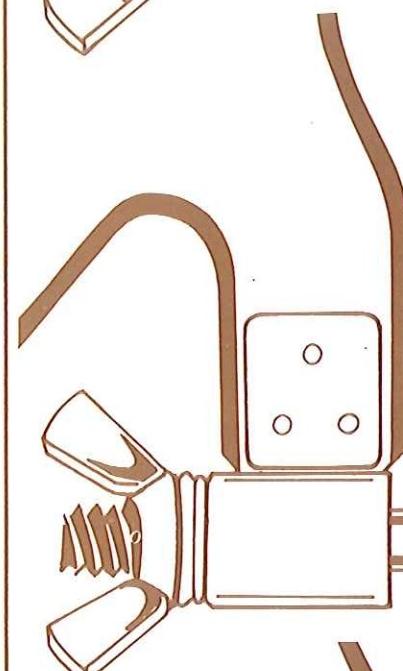
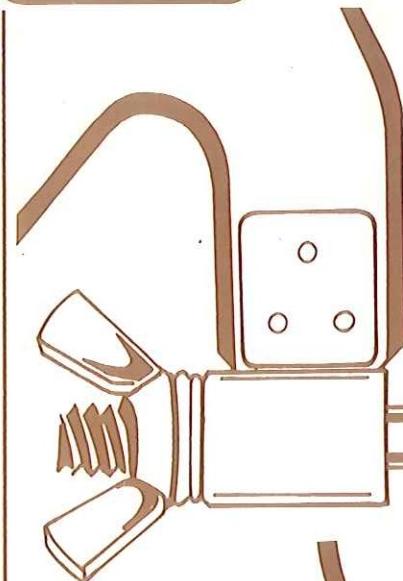
QUIK-CUT HOLE SAW STARTER KIT. Heat treated alloy steel for wood, plastics, wallboard and mild steel. Drills doors for lock sets. Carded.



Millers Falls

metal cutting products

HAND HACKSAW BLADES



"BLU-MOL"® HIGH SPEED HAND HACKSAW BLADES

"Blu-Mol" molybdenum high speed steel. Fully heat treated to resist wear and cut all metals efficiently. Recommended for applications involving firmly held work. Standard set on 14 and 18 tooth. Wavy set on 24 and 32 tooth.

Packed 100 Per Box.



Cat. No.	Lgth.	Teeth Per In.	Width	Thickness
1018M		18		
1024M	10"	24	1/2"	.025
1032M		32		
1214M		14		
1218M		18		
1224M	12"	24	1/2"	.025
1232M		32		

"BLU-FLEX"® HIGH SPEED HAND HACKSAW BLADES

"Blu-Flex" high speed molybdenum, shatter-proof, heat treated hard teeth with super-flexible back. Recommended when work cannot be firmly secured. Standard set on 14 and 18 tooth. Wavy set on 24 and 32 tooth.

Packed 100 Per Box.



Cat. No.	Lgth.	Teeth Per In.	Width	Thickness
*1018BF		18		
*1024BF	10"	24	1/2"	.025
*1032BF		32		
1214BF		14		
*1218BF		18		
*1224BF	12"	24	1/2"	.025
*1232BF		32		

*Also available 1 per plastic sleeve, 20 sleeves per box. To order letter S must precede Cat. No.

Example: S1018BF



"TUF-FLEX"® HAND HACKSAW BLADES

Super tough, super flexible patented alloy. Heat treated to resist breakage and tooth strippage. Best suited for light to medium duty general cutting. Standard set on 14 and 18 tooth. Wavy set on 24 and 32 tooth.

Packed 100 Per Box.

Cat. No.	Lgth.	Teeth Per In.	Width	Thickness
53FH		18		
63FH	10"	24	1/2"	.025
73FH		32		
45FH		14		
55FH		18		
65FH	12"	24	1/2"	.025
75FH		32		

